

20-7877



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2565-101
Job Sheet 205787



Part No: D2565-101

Job Qty: 4 pcs

DAS
21
9-80

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/20

Job Tracking No:

Due Date: 2/7/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP: F 02.04.16 Added dwg Rev.C1 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - Brake NC	4 pcs	2/7/20	2/7/20	0.25	0.55	Small Fab - Brake - 1	Michel 2020-1-22
							Small Fab - Brake - 2	
							Small Fab - Brake - 3	
120	QC 5	4 pcs	2/7/20	2/7/20	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
130	Powdercoat - 2 White GI(S)-B4B	4 pcs	2/7/20	2/7/20	0.00	0.10	Powdercoat - 1 - B4B	20-01-30
							Powdercoat - 2 - B4B	
							Powdercoat - 3 - B4B	
							Powdercoat - 4 - B4B	
140	QC 3	4 pcs	2/7/20	2/7/20	0.00	0.00	QC 3 - 10	
							QC 3 - 13	
							QC 3 - 15	
							QC 3 - 17	
							QC 3 - 18	



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Container No: S252143



Part: D2565-101

Job No: 205787

Serial No/Batch: S252143

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/30/20

Plex 1/17/20 10:00 AM Dart.lajeunesse.marie

						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	DAS
						QC 3 - 19	JAN 3 0 2020 40
						QC 3 - 43	9-89
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150 Packaging 3-1 - Stock - B4B	3	4 pcs	2/7/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	DAS
						Packaging 3 - 4 - B4B	ST353 80
						Packaging 3 - 5 - B4B	9-89
						Packaging 3 - 6 - B4B	JAN 3 0 2020
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
						Packaging 3 - 37 - B4B	
160 QC 21 - SA	3	4 pcs	2/7/20	0.00	0.00	QC 21 - SA - 21	ST353
						QC 21 - SA - 70	DAS
						QC 21 - SA - 53	21 JAN 3 1 2020

Part Op 100 - 1- Punch as per Dwg D2565 using DT 8313 2- Drill hole open to .316 Ø as per Dwg D2565 (one end only) 3- Debur

Descriptions: **120** - QC5- Inspect part completeness to step on W/O
130 - White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel - START TIME: _____
140 - QC3- Inspect Part Finish
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	6.8400 ft (1.71 ea)	100-Small Fab - Brake NC	5244044

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.750W.049	7	101	0

Part Specifications

Specifications could not be found.

Plex 1/17/20 10:00 AM Dart.lajeunesse.marie

2E

Feb 10/2020



NCR No.

26-7877

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>205787</u> Part No. <u>02565-101</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date : <u>JAN 30 2020</u>		Sequence #: <u>120</u>		QTY Affected : <u>1 of 4</u>		MRB (QSI042)																											
Description Work Order Deviation <u>Strut hole was punched twice one of which is in wrong position</u>				Disposition <u>Scrap destroy no replace</u>		PD 20-01-30 Completed By <u>40</u> 9-88 20-01-30 Lead hand / Supervisor PD 20-01-30 QC / QA Coordinator PD 20-01-30																											
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☒ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☒ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☒ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☒ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☒ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																															